

Work Order ID 75041

75041

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October-17-11 10:31:34 AM

Item ID: D3791-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 17/10/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3791	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3791								
304. 63	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B11-11-9

12

B11-11-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S n l u l u e			4/6			
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs	0.00 0.00	S n l u l u e			1/6			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429	0.00 0.00	S n l u l u e			4/6			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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October-17-11 10:31:34 AM

N900040100

Setup Start *NS1*

Stop *NS2*

12

12

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
180 Powdercoat Powder Coating	Memo START TIME: 8:30 OVEN TEMPERATURE: 320 °F FINISH TIME: 9:00	0.00							16x Ø M-11/11/17
190	QC3- Inspect Part Finish	0.00							
190 QC Quality Control	Memo	0.00							16 BR 11-11-17
200	Identify as per dwg & Stock Location <u>FD-2</u>	0.00							
200 Packaging Packaging	Memo	0.00							16 BR 11-11-17

W/O:		WORK ORDER CHANGES					
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(16)

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NOTE: Date & initial all entries

Picklist Print

October-17-11 10:31:39 AM

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Work Order ID: 75041

75041

Parent Item: D3791-1

D3791-1

Parent Item Name: Wearplate

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

30.2000

0.2917

3.684632

5

M304S16GA

**

HB11-11-9

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

30.2

118217

8

118964

22.2

119346

119346

(16)

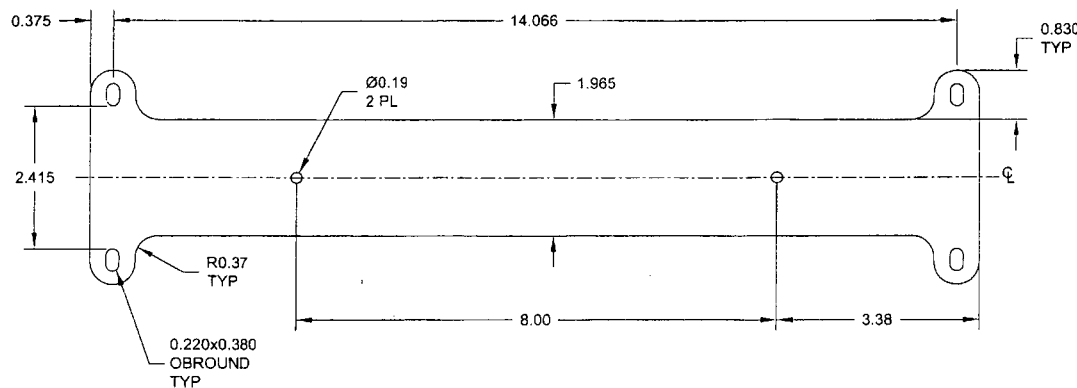
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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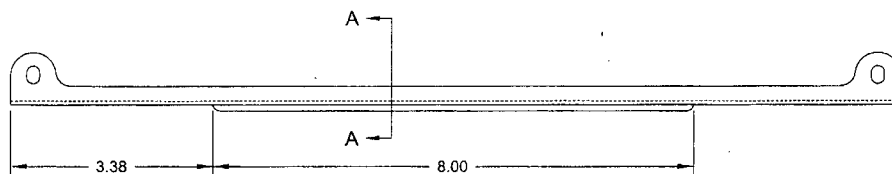
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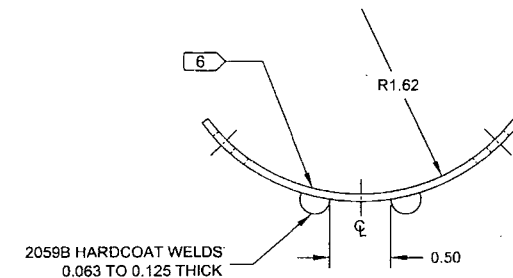
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 75041

11-10-17 RELEASED
 08-05-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.13
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.13			

DART AEROSPACE USA, INC
 PORT HADLOCK, WA
 DRAWING NO. REV. A
 D3791 SHEET 1 OF 1
 TITLE SCALE
 WEARPLATE NTS
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